



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA25A-3
Job Sheet 178807



003785

Part No: SWA25A-3

Job Qty: 1 ea

Part Name: Electric Swivel 25,000 lb Safe Work Load (11,340 kg)



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 6/7/18

Job Tracking No:

Due Date: 6/25/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA25A Rev 1 IPP Rev A 18.02.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		6/25/18	0.00	0.00	Start Up Small Fab-4		18-06-11 CB
110	Small Fab	1 pcs		6/25/18	0.00	2.00	Small Fab-9		AP
120	QC	1 pcs		6/25/18	0.00	0.00	QC5		SB
125	DC	1 pcs		6/25/18	0.00	0.00	DC		SB
130	Packaging	1 pcs		6/25/18	0.00	0.00	Packaging3		SRB DAS
140	QC21-FG	1 Ea		6/25/18	0.00	0.00	QC21		DAS JUN 29 2018 28

Part Op 110 - Assemble as per DWG. Sheet 1 ***All assembly to be done in accordance with SWA25A swivel manual*** Engrave Descriptions: T/N And / or S/N number as required Using Marktronic engraver as per DWG. Laser engrave dart logo as per DWG.

125 - Photocopy blue file OM & OOPM-SWA25A Rev2

130 - Bag and tag

GREASE AEROSHELL NO.7 (M138724) LOCTITE 242 (M138762) SILICONE "GE" (M138883)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1032-5/8 ✓	Set Screw	1 Ea (1 ea)	90-Start up Operation	5037083
188-FSCS-1032-5/8 ✓	Screw	4 Ea (4 ea)	110-Small Fab	5062757
EL-PLUG-F ✓	3-Prong Female Spade Plug	1 Ea (1 ea)	110-Small Fab	5058761
EL-PLUG-M ✓	3-Prong Male Spade Plug	1 Ea (1 ea)	110-Small Fab	5054451
EL314-SJTOW ✓	3 Wire	6 ft (6 ea)	110-Small Fab	5047767
SWA10A-1100 ✓	Upper DU Bearing	1 Ea (1 ea)	110-Small Fab	5060879
SWA10A-1200 ✓	Lower DU Bearing	1 Ea (1 ea)	110-Small Fab	change to 5079716 ← 5036190
SWA10A-1300 ✓	Roller Thrust Bearing	1 Ea (1 ea)	110-Small Fab	5047197
SWA10A-1400 ✓	Circlip	1 Ea (1 ea)	110-Small Fab	5049196
SWA10A-1800 ✓	Cover	1 Ea (1 ea)	110-Small Fab	5081519 ← 5031915
SWA10A-300 ✓	Bearing Housing	1 Ea (1 ea)	110-Small Fab	5034295
SWA10A-400 ✓	Thrust Washer	1 Ea (1 ea)	110-Small Fab	5049940
SWA10A-500 ✓	Semi-Rings	1 Ea (1 ea)	110-Small Fab	5029393
SWA10A-600 ✓	Collar	1 Ea (1 ea)	110-Small Fab	5034519
SWA10A-700 ✓	Wire Clamp	2 Ea (2 ea)	110-Small Fab	5038666
SWA25A-100 ✓	Lower End	1 Ea (1 ea)	110-Small Fab	5029395
SWA25A-200 ✓	Upper End Swivel	1 Ea (1 ea)	110-Small Fab	5029396
SWA6A-1900 ✓	Female Spade Terminal - 1/4"	6 Ea (6 ea)	110-Small Fab	5054299
SWA6A-800B ✓	Connector Bushing	1 Ea (1 ea)	110-Small Fab	5029420
SWA6A-900B ✓	Rotary Contact	1 Ea (1 ea)	110-Small Fab	5072691

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation 110-Small Fab	188-FPSS-1032-5/8	1	375	0
	188-FSCS-1032-5/8	4	489	0
	EL-PLUG-F	1	39	0
	EL-PLUG-M	1	76	0
	EL314-SJTOW	6	917	0
	SWA10A-1100	1	7	0
	SWA10A-1200	1	28	0
	SWA10A-1300	1	37	0
	SWA10A-1400	1	37	0
	SWA10A-1800	1	3	0
	SWA10A-300	1	3	0
	SWA10A-400	1	5	0
	SWA10A-500	1	38	0
	SWA10A-600	1	5	0
	SWA10A-700	2	15	0
	SWA25A-100	1	0	0
	SWA25A-200	1	0	0
	SWA6A-1900	6	274	0
	SWA6A-800B	1	0	0
	SWA6A-900B	1	12	0

Part Specifications

Specifications could not be found.

Plex 6/7/18 2:37 PM dart.lajeunesse.marie



Container No: S079557



Part: SWA25A-3

Job No: 178807

Serial No/Batch: S079557

Revision: 1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/11/18



Electric Swivel

SWA25A

Work Order 178807

Customer _____

Number of Wires 3Date 2018/06/29Serial Number 5079557

Number of Cycles	Load (Lbs.)	Action	Pass/Fail
1	25,000	Check for Conductivity against all wires.	- PASS
1	25,000	Check all wires for grounding against swivel body.	- PASS
1	12,500	Check for Conductivity against all wires.	- PASS
1	12,500	Check all wires for grounding against swivel body.	- PASS
1	6,250	Check for Conductivity against all wires.	- PASS
1	6,250	Check all wires for grounding against swivel body.	- PASS
1	0	Check for Conductivity against all wires.	- PASS
1	0	Check all wires for grounding against swivel body.	- PASS

Test Conducted By:

Alain PATRY

Technician

Submit

Signature:

Sylvie Sanchez
QC 5/Small FAB / QA

WORK ORDER NON-CONFORMANCE / UPDATE

Date: _____

QA Closed:

Date: _____

Work Order update only ☐

Work Order: <u>178807</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. <u>SWA25A-3</u>		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No.		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Large Fab ☐	Composite ☐	Supplier ☐			

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation REPLACE P/N: SWA10A-700 WIRE CLAMP WITH P/N: SW10A-700A	Disposition - THE SW10A-700A CLAMP PROVIDES A SUPERIOR CLAMP ON THE WIRE WITHOUT DAMAGING THE WIRE. - THIS DEVIATION IS ACCEPTABLE	Completed By <u>A. PATRY</u> Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval
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Root Cause			FAULT CATEGORY					
Environment ☐	☐ No Re-verification	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☒	☐ Operator	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐ Offset/Setup	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under toleran ☐			
Equip/Tooling ☐	☐ Supplier	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐ Training	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐ Use for Testing	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐ Poor Information	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐ Rushing	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐ Product Improvement	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐ Process Improvement	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐ Manufacturing Process							
Misidentified ☐	☐ Past Due	OTHER :						